

Ship 13 Feb.

Work Order ID 156563

156563

Page 1

Monday, January 30, 2017 2:06:30 PM

Item ID: D412-761-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bubble Window
 Start Date: 2/3/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/9/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: JAN 30 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-761	G

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-045 CHG003								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
6
9-89

FEB 02 2017

DAS
27
9-89
FEB 21 2017

1 FEB 02 2017 DAS
6
9-89 DAS
28
9-89

DAS
27
9-89
FEB 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Work Order ID 156563

Monday, January 30, 2017 2:06:30 PM

156563

Page 2

Item ID: D412-761-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bubble Window

Start Date: 2/3/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/9/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1			
130							DAS 27 9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-045								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC									
Quality Control	Memo	0.02							

FEB 21 2017

FEB 21 2017

mf
17-2-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Monday, January 30, 2017 2:06:36 PM

Page 1

Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B
13.01.15 as per ECN13-511 DD Verf:JLM IPP Rev:C 16.06.21
PER IIN REV.F DD Verf:JLM IPP REV:D 16.06.24 PER
CH003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS43DD3-24

Purchased

No

Each 29.0000

1

NAS43DD3-24

Spacer for bolt

**

DAS 6 9-89

FEB 02 2017

Location

Loc Qty

Loc Code

ST550

29

M128454

29

D3704-3

Manufactured

No

110

Each

0.0000

1

1

D3704-3

Escutcheon

D412-761-043

Manufactured

No

110

Each

2.0000

1

1

D412-761-043

Modified Latch Mechanism, LH

**

DAS 6 9-89

FEB 02 2017

Location

Loc Qty

Loc Code

FG020

2

144456

2

D3676-1

Manufactured

No

110

Each

0.0000

1

1

D3676-1

Bubble Window, LH

D3678-1

Manufactured

No

110

Each

7.0000

1

1

D3678-1

Placard

**

DAS 6 9-89

FEB 02 2017

Location

Loc Qty

Loc Code

ST051

7

145256

1

147806

6

DAS 27 9-89

DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3678-3 Manufactured No

110 Each 7.0000 1 1

D3678-3

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

7

145257

1

147807

6

DAS
6
9-89 FEB 11 2 2017

MF

D3678-5 Manufactured No

110 Each 8.0000 1 1

D3678-5

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

8

154099

2

154444

6

12/10/2017

12/23/2017

DAS
6
9-89 FEB 10 2 2017

MF

D3700-1 Manufactured No

110 Each 9.0000 1 1

D3700-1

Inboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

9

146874

9

DAS
6
9-89 FEB 10 2 2017

MF

D3700-3 Manufactured No

110 Each 3.0000 1 1

D3700-3

Outboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

3

146914

3

DAS
6
9-89 FEB 10 2 2017

MF

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Monday, January 30, 2017 2:06:36 PM

Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3701-1
D3701-1

Floor Doubler

Manufactured No

110 Each

6.0000

1 1

**

FEB 02 2017

DAS 6 9-89 MF

Location

Loc Qty

Loc Code

st238

6

146942

6

D3702-1
D3702-1

Fwd Doubler

Manufactured No

110 Each

4.0000

1 1

**

FEB 02 2017

DAS 6 9-89 MF

Location

Loc Qty

Loc Code

st238

4

148405

4

D3703-1
D3703-1

Aft Doubler

Manufactured No

110 Each

2.0000

1 1

**

FEB 02 2017

DAS 6 9-89 MF

Location

Loc Qty

Loc Code

ST239a

2

113680

2

D3703-3
D3703-3

Aft Corner Doubler

Manufactured No

110 Each

3.0000

1 1

**

FEB 02 2017

FEB 02 2017

DAS 6 9-89 MF

Location

Loc Qty

Loc Code

st239

3

151747

3

D3703-5
D3703-5

Aft Cap

Manufactured No

110 Each

15.0000

1 1

**

FEB 02 2017

DAS 6 9-89 MF

Location

Loc Qty

Loc Code

ST052

15

146016

15

Monday, January 30, 2017 2:06:36 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Page 4

Monday, January 30, 2017 2:06:36 PM

Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3704-1
D3704-1
Escutcheon

Location	Loc Qty	Loc Code
ST052	5	
146856	5	

D3708-1
D3708-1
Angle

Location	Loc Qty	Loc Code
ST052	5	
146856	5	

D3708-3
D3708-3
Angle

Location	Loc Qty	Loc Code
ST052	5	
146856	5	

D3709-1
D3709-1
Angle

Location	Loc Qty	Loc Code
ST052	5	
146856	5	

D3709-3
D3709-3
Angle

Location	Loc Qty	Loc Code
ST052	5	
146856	5	

DAS
27
9-89

Monday, January 30, 2017 2:06:36 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

D3802-1 Manufactured No 110 f 18.3158 13.5 13.5

***D3802-1*-135**

Window Seal (\$ per foot)

**** 136/39**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST416

18.31578947

153922

18.3157895

DAS
6
9-89

FEB 02 2017

1- Cut one per dwg d3802-1-135

DT9458

Manufactured Yes

110 Each

0.0000

1

1

DT9458

Cutting Template

AN3-7A

Purchased No

110 Each

164.0000

26

26

AN3-7A

Bolt

DAS
6
9-89

FEB 02 2017

DAS
6
9-89

FEB 02 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST349

164

m135058

164

110 Each

813.0000

52

52

NAS1149D0363J

Purchased

No

NAS1149D0363J

Washer

DAS
6
9-89

FEB 02 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

233

m134055

233

ST263

580

m136318

580

SZ

MC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Monday, January 30, 2017 2:06:36 PM

Work Order ID: 156563

156563

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 2/3/2017

Required Date: 2/9/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 110 Each 1,917.000 26 26

MS21042L3

Nut

Location	Loc Qty	Loc Code
FP001	100	
m135945	100	
GA	158	
m134360	108	
m135135	50	
OVER007	1000	
M136554	500	
M136665	500	
ST303	659	
M136192	159	
M136406	500	

DAS
27
9-89

DAS
6
9-89

FEB 02 2017

mf

MS24694-C5 Purchased No 110 Each 95.0000 1 1

MS24694-C5

Screw

Location	Loc Qty	Loc Code
ST285	95	
m130238	95	

DAS
27
9-89

DAS
6
9-89

FEB 02 2017

mf

MS24694-C13 Purchased No 110 Each 7.0000 1 1

MS24694-C13

Screw

Location	Loc Qty	Loc Code
ST285	7	
108558	7	

DAS
27
9-89

DAS
6
9-89

FEB 02 2017

mf

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
OTHER : _____					

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
							X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
		1							D3676-1	LARGE BUBBLE WINDOW
		1							D3678-1	PLACARD
		1							D3678-3	PLACARD
		1							D3678-5	PLACARD
		1							D3700-1	INBOARD WINDOW DOUBLER
		1							D3700-3	OUTBOARD WINDOW DOUBLER
		1							D3701-1	FLOOR DOUBLER
		1							D3702-1	FORWARD DOUBLER
		1							D3703-1	AFT DOUBLER
		1							D3703-3	AFT CORNER DOUBLER
		1							D3703-5	AFT CAP
		1							D3704-1	ESCUTCHEON
		1							D3704-3	ESCUTCHEON
		1							D3708-1	ANGLE
		1							D3708-3	ANGLE
		1							D3709-1	ANGLE
		1							D3709-3	ANGLE
		1							D3802-1-135	SEAL
		1							DT9458	CUTTING TEMPLATE
		26							AN3-7A	BOLT
		26							MS21042L3	NUT
		1							MS24694-C5	SCREW (OR MS24694-S5)
		1							MS24694-C13	SCREW (OR MS24694-S13)
		1							NAS43DD3-24	SPACER
		52							NAS1149D0363J	WASHER (OR AN960JD10)

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
X											D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X										D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1					X				D412-761-049	ARMREST KIT, LH
			1					X			D412-761-051	ARMREST KIT, LH
									X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1	1									X	D412-761-141	VENT KIT
1	1										204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153	BELL 204, 205, 210, 412 OEM DOOR